



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2842-041
Job Sheet 167716



Part No: D2842-041

Job Qty: 4 ea

Part Name: Step Assembly, LH, 206 Float



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/6/17

Job Tracking No:

Due Date: 12/6/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/5/17	0.00	0.00	Start Up Large Fab2		12/11/17-26
100	Large Fab	4 pcs		12/5/17	0.00	5.88	Large Fab 8		12/11/17-26
110	QC	4 pcs		12/5/17	0.00	0.00	QC6		JPC
120	Large Fab	4 pcs		12/5/17	0.00	5.88	Large Fab 2		
130	QC	4 pcs		12/5/17	0.00	0.00	QC9		12/12/17
140	QC	4 pcs		12/5/17	0.00	0.00	QC5		12/12/17
150	HandFinish	4 pcs		12/5/17	0.00	1.48	HandFinish1		2017-12-05 JSC
160	QC	4 pcs		12/5/17	0.00	0.00			
160	QC	4 pcs		12/5/17	0.00	0.00	QC7		
170	Large Fab	4 pcs		12/5/17	0.00	5.88	Large Fab 2		12/12/17
180	QC	4 pcs		12/5/17	0.00	0.00	QC10		38 DAS
190	QC	4 pcs		12/5/17	0.00	0.00	QC5		9-88 38
191	HandFinish	4 pcs		12/5/17	0.00	1.48	HandFinish2		BEB 12/12/17
200	Powdercoat	4 pcs		12/5/17	0.00	0.96	Powdercoat1		12/12/17
210	QC	4 pcs		12/5/17	0.00	0.00	QC3		BEB 12/12/17
220	HandFinish	4 pcs		12/6/17	0.00	1.48	HandFinish4		BEB 12/12/17
230	QC	4 pcs		12/6/17	0.00	0.00	QC5		38
240	Packaging	4 pcs		12/6/17	0.00	0.00	Packaging3		9-88 Smb
250	QC21-SA	4 Ea		12/6/17	0.00	0.00	QC21		

Part Op 100 - 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 2-Drill D2842-1 using Jig DT8271 as per Dwg D2842 2-Grind end cap weld flush 3- Open hole as per dwg and deburr(0.250")

Descriptions: ***DO NOT OPEN HOLES*** 3-Debur and bevel ends for welding

120 - 1-Weld one end cap and (2) lugs using Jig DT10038 as per Dwg D2842 2-Grind end cap weld flush 3- Open hole as per dwg and deburr(0.250")

170 - 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.

191 - ***Touch up step with alodine per qsi 005 prior to powder coat***

200 - START TIME: 8:30 OVEN TEMPERATURE: 350 FINISH TIME: 9:00 M138464

220 - 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: M138423

Sika Flex M138654 EIP 18-04.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	NAS1149C0332R FM138409	12	2,412	0	0
120-Large Fab	D2622-120C	4	14	0	0
	D2734 5013269	8	14	0	0
	D3459-3 5012447	8	13	0	0
220-HandFinish	D3459-1	8	14	0	0
	MS27039C1-07 FM132317-1012	89	89	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

8023251 x6
NAS1329C3KB130 FM132803 x6
NAS1515H3L FM137361-25
12

29	0	0
222	0	0

Part Specifications

Specifications could not be found.

DQA: _____

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work

Date

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com



Step Assembly, LH, 206 Float

PART NO: D2842 - 041**Revision: Large Fab****Operation: Change No:**

Mfg Date: 11/27/17
Job No: 167716

AGAINST DEPARTMENT/PROCESS			
Work	Skid-tube	Cross tube	Water Jet
ap	Machining	Small Fab	Prod. Eng. Coord.
-is	Thermoforming	Finishing	Rec/Store/Packaging
ed	Large Fab	Composite	Supplier
QTY Effective :			MRB (QSI042) Approval
Disposition			Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval
FAULT CATEGORY			
☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	
☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	
☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	
☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	
☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	
☐ Contamination	☐ Out of Sequence	☐ Part Moved	
☐ Countersink	☐ Off-set	☐ Drawing	
☐ Cut Too Short	☐ Misabeled	☐ Finish	
☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	
☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence	

Inte

Tri

LOA

Substation

Past Expiry Date

Misidentified

Product Improvement

Process Improvement

Manufacturing Process

Past Due

Wave/Twist in Tube

Marks/Chatter

OTHER :